



Dart Hawkesbury
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Tel (613) 632-5200

D3197-041
Job Sheet 166724



Part No: D3197-041

Job Qty: 4 ea

Part Name: Bar



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/16/17

Job Tracking No:

Due Date: 10/31/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	4 Ea	10/30/17	0.00	0.00	Start up container	
100	Bandsaw	4 pcs	10/30/17	0.00	0.35	Bandsaw1	
110	CNC Vertical Machining	4 pcs	10/30/17	0.51	2.96	HAAS 1	
120	QC	4 pcs	10/30/17	0.00	0.00	QC2	
130	Lathe Conv	4 pcs	10/30/17	0.00	0.70	Lathe Conv 1 Charles	
140	QC	4 pcs	10/30/17	0.00	0.00	QC8	
150	HandFinish	4 pcs	10/30/17	0.00	0.34	HandFinish1	
160	Powdercoat	4 pcs	10/30/17	0.00	0.17	Powdercoat3	
170	QC	4 pcs	10/30/17	0.00	0.00	QC3	
180	Small Fab	4 pcs	10/31/17	0.00	1.02	Small Fab	
190	QC	4 pcs	10/31/17	0.00	0.00	QC5	
200	Packaging	4 pcs	10/31/17	0.00	0.00	Packaging3	
210	QC21-SA	4 Ea	10/31/17	0.00	0.00	QC21	

Part Op 100 - Cut blanks: 29.125" long

Descriptions: 110 - 1-Face ends to length per dwg D3197 2-Machine D3197-1 as per Folio FA340 and Dwg D3197

130 - Chamfer as per Dwg D3197

160 - START TIME: 3:25 O.V.T: 3:20 FINISH: 3:55

180 - Assemble D3197-041 as per Dwg D3197

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	MS27039-1-24 F1134537-10	8	50	0	0
180-Small Fab	D2690-5 S000841 2x	8	6	0	0
	D3242-1 F157274 1x F163841 2x	8	13	0	0
	D3489-3-200 F162049 7x	8	7	0	0
	M7075T73R1.000	10	16	0	0
	MS21042L3 S000676	8	462	0	0
	NAS1149D0363J F1137983-15	24	955	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

Date : _____ Step #: _____

Description Work Order

DISPOSITION

Rework ☐Skid-tube ☐
Machining ☐

AGAINST DEPARTMENT/PROCESS

Cross tube ☐
Small Fab ☐Water Jet ☐
Prod. Eng. Coord. ☐
Packaging ☐Engineering ☐
Quality ☐
Other ☐

SLS
DART
AEROSPACE
S005801

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MRB (QS1042) Approval

Completed By

Lead hand / Supervisor
Approval VerificationQC / QA Coordinator
Approval

Bar

PART NO:
Revision:
Operation:
Quantity:
Change No:

D3197-041

Start up Operation
4

Mfg Date: 11/03/17
Job No: 166724

Root Cause

Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

Pressure/force

Bending

Centre Not Concentric

Cracks

Crimp/Kink/Ripple/Wave

Cuffs

Crushing

Heat Treat

Wave/Twist in Tube

Marks/Chatter

OTHER :

Set-up

BOM/Route

Broken/Damage/Defect

Inspection Incomplete/Unqualified

Contamination

Countersink

Cut Too Short

Instructions Incomplete/Unclear

Drill Holes

Grain

Weld

Wrong Stock Pulled

Out of Sequence

Off-set

Mislabelled

Fit/Function

Misaligned/off center

Positioned Wrong

Outside Dimensions

Over/Under tolerance

Part Incorrect

Part Lost/Missing

Part Moved

Drawing

Finish

Misread

Turning Sequence

